

Work Order ID 98835

Tuesday, March 26, 2013 9:03:52 AM

98835

Page 1

Item ID: D4081-1

Accept

Revision ID:

Item Name: Bushing

Start Date: 3/26/2013 Start Qty: 10.00

10

Required Date: 3/26/2013 Req'd Qty: 10.00

10

Reference:

Approvals: Process Plan: *MF*

Date: 3-3-26 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4081	A
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100

100

Hardinge

Hardinge CNC Lathe Small

Memo

Turn as per Dwg and Folio FA928

DWG REV: *H*

FOLIO REV: *M*

0.00

0.00

26 3-3-26 10 f

DEBURR

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

26 3-3-26 10 f

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Item ID: D4081-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Bushing

Stop

NS2

Start Date: 3/26/2013 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 3/26/2013 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

120

120

QC

Quality Control

**Operation
Description**

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

5/

13-3-26

10

130

130

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

10 13-3-26

140

140

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

13-3-26 (10)

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Item ID: D4081-1

Accept

Revision ID:

Item Name: Bushing

Start Date: 3/26/2013 **Start Qty:** 10.00

10

Required Date: 3/26/2013 **Req'd Qty:** 10.00

10

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

150

150

Packaging

Packaging

**Operation
Description**

Identify as per dwg & Stock Location: _____

H 0 92

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

MLJ 13-03-26

Memo

0.00

MF

13-03-26

Picklist Print

Tuesday, March 26, 2013 9:03:51 AM

Page 1

Work Order ID: 98835

Parent Item: D4081-1

Parent Item Name: Bushing

Start Date: 3/26/2013

Required Date: 3/26/2013

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-05-04 JLM VERIFIED BY:EC
11/05/18 JFS verf: DD IPP REV:B change material size

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058 6061-T6 RD Tube .375 x.058W		Purchased	No			100	f	385.8490	0.104	1.0947368			

Location	Loc Qty	Loc Code
MAT014	385.849	
116920	1.156	
119087	0.11	
123303	8	
123449	249.8	
123844 ✓	112.517	
124069	14.266	

SP P - 3 - 26

8

7

6

5

4

3

2

1

D

C

B

A

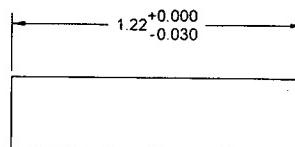
D

C

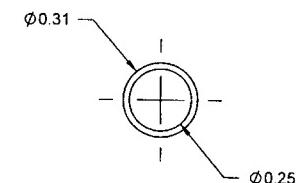
B

A

95835



1.190



D4081-1 BUSHING

- NOTES:
 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING
 PER VW-T-700/6 OR AMS4080 OR AMS4082
 OR QQ-A-200/8 OR QQ-A-225/8
 REF DART SPEC M6061T670.375W.058
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.00 lbs

A	NEW ISSUE	B	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN	KB	DART AEROSPACE LTD	
DRAWN	KB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BB	DRAWING NO.	REV. A
MFG. APPR.	BB	D4081	SHEET 1 OF 1
APPROVED	BB	TITLE	SCALE
DE APPR.	BB	BUSHING	NTS
DATE	10.02.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS THE CONFIDENTIAL PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8

1

7

6

5

4

3

2

1

1.22

DART AEROSPACE LTD	Work Order:	98835
Description: Bushing	Part Number:	D4081-1
Inspection Dwg: D4081	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	Raf	Audited by:		Preliminary Approval:	
Date:	3-3-26	Date:	18-3-26	Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	